

Work Order ID 127428

127428

Page 1

December-17-14 1:23:49 PM

Item ID: D4365-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 12/16/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-12-19 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4365	A								

100		0.00							
100									
Cold Saw	Memo	0.00							
Hyd Mech	Cut blanks at 64.39"								
110		0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Mill as per folio FB040 & dwg D4365, FOLIO REV: <u>A</u> DWG REV: <u>A</u> 2-Deburr as required								

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 25%;">Skid-tube ☐</td> <td style="width: 25%;">Crosstube ☐</td> <td style="width: 25%;">Water Jet ☐</td> <td style="width: 25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				4	0		DAS 44 9-89 15/01/09.
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				4	0		JFL 2015-01-12
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <i>N/A 001</i> Memo	0.00 0.00				4	0	15-10/4	

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Work Order ID 127428***127428***

Page 3

Item ID: D4365-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bar

Stop ***NS2***

Start Date: 12/16/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 4.00

4

Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21 - Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MLJ 15-01-14

DQA: _____ Date: _____



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Picklist Print

December-17-14 1:23:49 PM

Page 1

Work Order ID: 127428

127428

Parent Item: D4365-3

D4365-3

Parent Item Name: Bar

Start Date: 12/16/14

Required Date: 12/17/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.04.12 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	88.4160	5.375	22.63158			

M304B0 250x0 500

**

304 BAR .250 x .500

Location

Loc Qty

Loc Code

MAT009

88.416

m129366

88.416

131205

PK 15/01/09

21.5

DQA: _____ Date: _____



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D4365-1 BAR

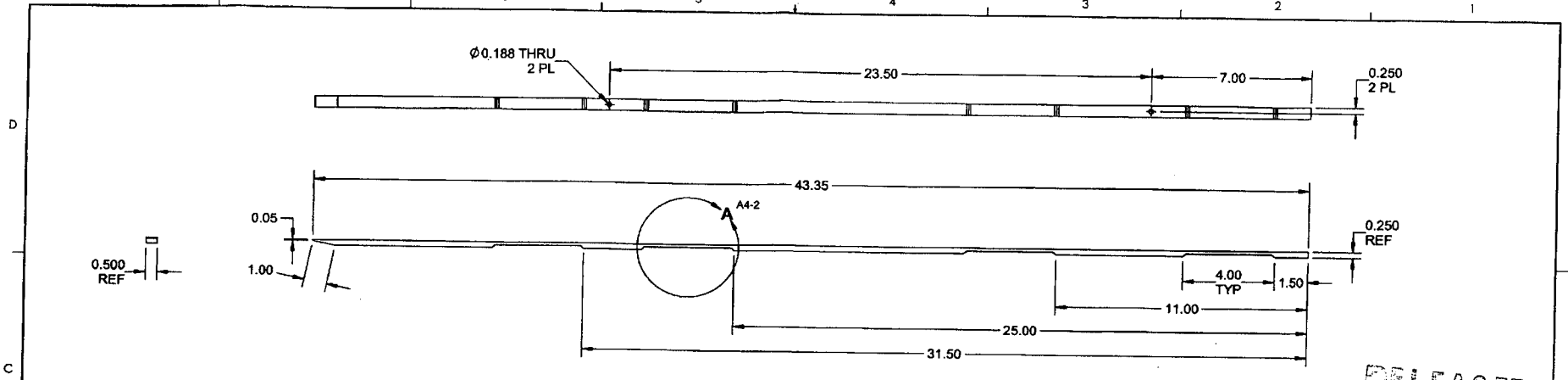
D4365-3 BAR

WORK COPY
 NOT FOR
 CONSTRUCTION
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 127428 MLC
 14-12-19

RELEASED
 2011-09-12
 AM

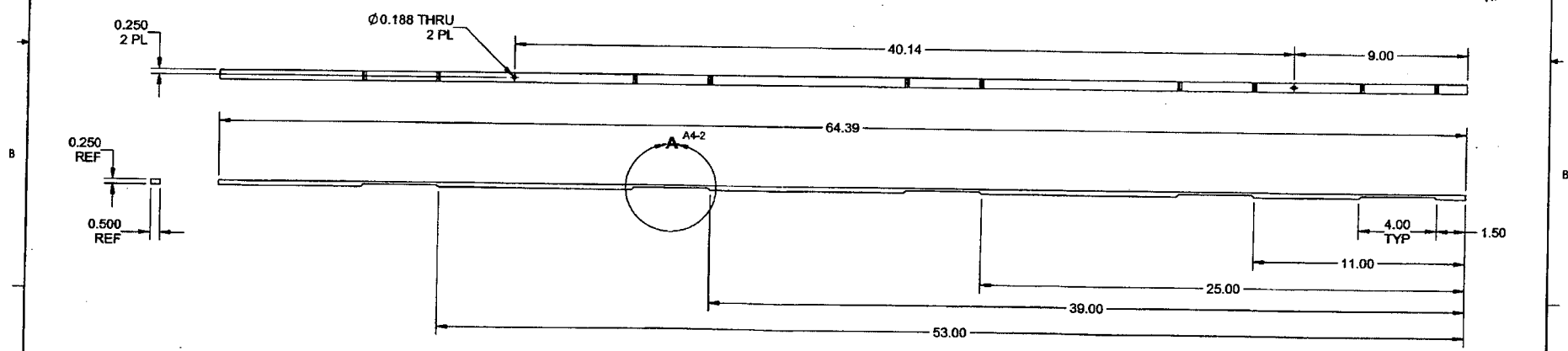
A		NEW ISSUE		SC	11.06.14
REV.	DESCRIPTION			BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.			REV. A
DRAWN	SC	PORT HADLOCK, WA			SHEET 1 OF 2
CHECKED	SC	DRAWING NO. D4365			SCALE
MFG. APPR.	SC	TITLE BAR			NTS
APPROVED	SC	DATE 11.06.14			
DE APPR.	SC	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS EMPLOYED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMPARISONED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

8 7 6 5 4 3 2 1



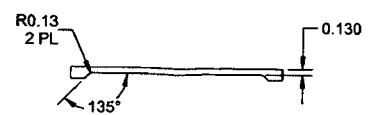
D4365-1 BAR

RELEASED
2011-09-12
MD



D4365-3 BAR

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR. 0.250 THICK X 0.500 WIDE
PER ASTM A276 OR ASTM A240
REF. DART SPEC. M304B0.250X00.500
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: D4365-1 = 1.28 lbs
D4365-3 = 1.98 lbs



DETAIL A
TYP B5-2
DS-2

DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	UP	DRAWING NO. D4365	REV. A
MFG. APPR.	ES	SHEET 2 OF 2	
APPROVED	MD	TITLE BAR	SCALE NTS
DE APPR.		COPYRIGHT © 2011 BY DART AEROSPACE USA, INC.	
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8 7 6 5 4 3 2 1